

Date: Thursday, 31/07/2008 10:52:47 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 A/B HIGH GEAR SKIDTUBE
Job Number :	40841		
Estimate Number :	10171		
P.O. Number :		Part Number :	D206642213
This Issue :	31/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	1/1	Project Number :	N/A
Previous Run :	40840	Drawing Revision :	L
Written By :		Material :	
Checked & Approved By :	<u>JULIE 08.7.31</u>	Due Date :	08/08/2008
Comment :	Est Rev:K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:		
		Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP206-642-213 CHG004

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	40841A	HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
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Comment: Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

1 x D206-642-241 Batch 1540844A

4.0	D206651041	206A/B GHW
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D206-651-041	GHW Kit	<u>1541773</u>
1	D206-642-241(REF)		<u>40841A</u>

5.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
16	D2652	Bushing	<u>1540277</u>

8/8/14

30

20

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 40841

Part Number: D206642213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655

Tow Ring

1537328

SP

7.0

D26651

Saddle, LH Fwd Aft Out 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2665-1

Saddle

1537330

SP

8.0

D26661

Saddle, LH Fwd Aft In 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2666-1

Saddle

1537332

SP

9.0

D26671

Saddle, LH Aft Out 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2667-1

Saddle

159051

SP

10.0

D26681

Saddle, LH Aft In 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2668-1

Saddle

1511134

SP

11.0

D2712

Set Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 D2712

Set Screw

1537765

8/8/14

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40841

Part Number: D206642213

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D2884	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

2 D2884 SADDLE SPACER

Batch

M35497

SC

13.0	D2885	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

2 D2885 SADDLE SPACER

Batch

M37342

SC

14.0	AN341A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 AN3-41A Bolt

Batch

M108302

SC

15.0	AN45A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

1 AN4-5A Bolt

Batch

M15247

SC

16.0	AN46A	Bolt
------	-------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

12 AN4-6A Bolt

Batch

M16067

M107534

SC

17.0	AN57A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

4 AN5-7A Bolt

Batch

M10703

8/8/14

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 40841

Part Number: D206642213

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

4 AN5-11A

Description Batch

Bolt

M108377

SC

19.0

AN532A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 AN5-32A

Description Batch

Bolt

M107013

SC

20.0

AN644A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

2 AN6-44A

Description Batch

Bolt

M10471

SC

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN960JD10

Description Batch

Washer

M108558

SC

22.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number

25 AN960JD416

Description Batch

Washer

M128161

8/8/14

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 40841

Part Number: D206642213

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD516 Washer M108246

SP

24.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN960JD616 Washer M107959

SP

25.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS21042L3 Nut (or -3) M107605

SP

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 MS21042L4 Nut (or -4) M108480

SP

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 MS21042L5 Nut (or -5) M108471

SP

28.0

MS21042L6

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 MS21042L6 Nut (or -6) M105077

8/8/14

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 31/07/2008 10:52:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 40841

Part Number: D206642213

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



08-08-14 (1)



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



(1/2)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-213

Location: REV D

8/8/14

30

31.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



08/08/15

40841A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 10:52:47 AM
User: Julie Lecocq

Process Sheet

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Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR SKIDTUBE
Job Number : 40841	
Estimate Number : 10171	
P.O. Number :	Part Number : D206642213
This Issue : 31/07/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : L
Previous Run : 40840	Material :
Written By :	Due Date : 08/08/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JULIE LECOCQ</u>	
Comment : Est Rev:K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:	

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUL 08/8/7



Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP206-642-213 CHG004

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	40841A	HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
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Comment: Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
1 x D206-642-241 Batch

4.0	D206651041	206A/B GHW
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D206-651-041 GHW Kit
1 D206-642-241(REF)

5.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 D2652 Bushing

Date: Thursday, 31/07/2008 10:53:12 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
 Job Number : 40841A
 Estimate Number : 10163
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206642241
 First Issue : 1/1 Type : SKIDTUBES Drawing Number : D2650 REV E
 Previous Run : 40840A Project Number : N/A
 Material :
 Due Date : 08/08/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JULIE LECOCQ
 Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG003

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

B 40451 ① M 8-7-31

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler

B 40437 BE 08/08/05

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647

Fwd Cap B 35475 BE 8-7-31

5.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

M 8-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

u 8-7-31

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m108096/107877 8E 8-7-31*

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

3E 08/08/06

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK



S 08/08/06 (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

BF 08/08/06

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 8-8-06

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-8-6

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

BF 8-8-6

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 8/8/6 (W)

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch
52 CR3212-4-04 Rivet 108688

BF 08/08/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D26543	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

240881

BE 08-08-06

14.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

BE 08/08/06

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: *08-08-06* Time: *2:00*

Finish Date: *8/8/7* Time: *7:15am*

BE 08/08/06

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date:

m 108801
10/2008

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2 08/08/07

16.0	D2649	Cross Bolt Spacer
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Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649

Crossbolt spacer

2 37883

BE 08/08/07

17.0	D32863	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

2 D3286-3

Description Batch

Spacer

2 37783

BE 08/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1:



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m107877

BE 08/08/07

2-Grind welds flush as per Dwg D2650.

BE 08/08/07

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod

NONE

BE 08/08/07

(P10)

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

BE 08/08/07

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m108738

m108746

BE 08/08/07

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

m102515

BE 08/08/07

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

234599

BE 08/08/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-241 PAR #: N/A Fault Category: Prod / Skid tube NCR: ☒ Yes ☐ No DQA: D Date: 28/08/15
 QA: N/C Closed: D Date: 28/08/15

NCR: <u>4084/A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/07</u>	<u>16.4</u>	Ducking counter boring the counter bore pilot feed out and caused the 1st saddle hole on the PWD END. to be ovalized.	<u>08.08.07</u>	Drill out 1st saddle hole & bolt space. Repbce D2649 B2 <u>39883</u> (x1)	<u>BE</u> <u>08/08/07</u>	<u>S</u> <u>elole</u>	<u>08.08.07</u>	<u>S</u> <u>elole</u>
		R.L. Pilot for came out during counter boring		Re weld as per QST004 and grind flat then Re welder here. <u>MR M107877</u>	<u>BE</u> <u>08/08/07</u>			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 10:53:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

ZE 08/08/07

23.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

S 08/08/12 / PD 08-03-08

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (X)

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

PD 08-08-12 (X)

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:15
320 OF
2:45

M-1 08/08/12

(1X)

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/08/12 (1)

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2648-3

Wearpad

B37591

FD 08/08/13 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B35542.

FL

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B38748

FL

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B29452

FL

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B46438

FL

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

or (see QSI 017)

B m/105819

FL 08/08/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 10:53:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	AN960JD10L	Washer	m104885

FL

35.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	MS27039-1-08	Screw	m108097

FL

36.0	D26511	Plug
------	--------	------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2651-1	Plugs	B40435

FL

37.0	D26513	O-Ring
------	--------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2651-3	O-Rings	B38742

FL

38.0	MS27039406	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS27039-4-06	Screw	m107862

FL

39.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416	Washer	m105426

FL 08/08/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 10:53:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date:

m/108801
08/10

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

FL ①
08/08/13

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

1537377

FL

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

m/108801
08/10

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch:

m/107892

FL 08/08/13 ①

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/08/13 ④

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/13 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 10:53:12 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40841A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location:

PPP Rev:

81
PPP 40841 8/8/14

(X)
SD

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
28.08.15

Job Completion



11 28.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
06 04 17 *PH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

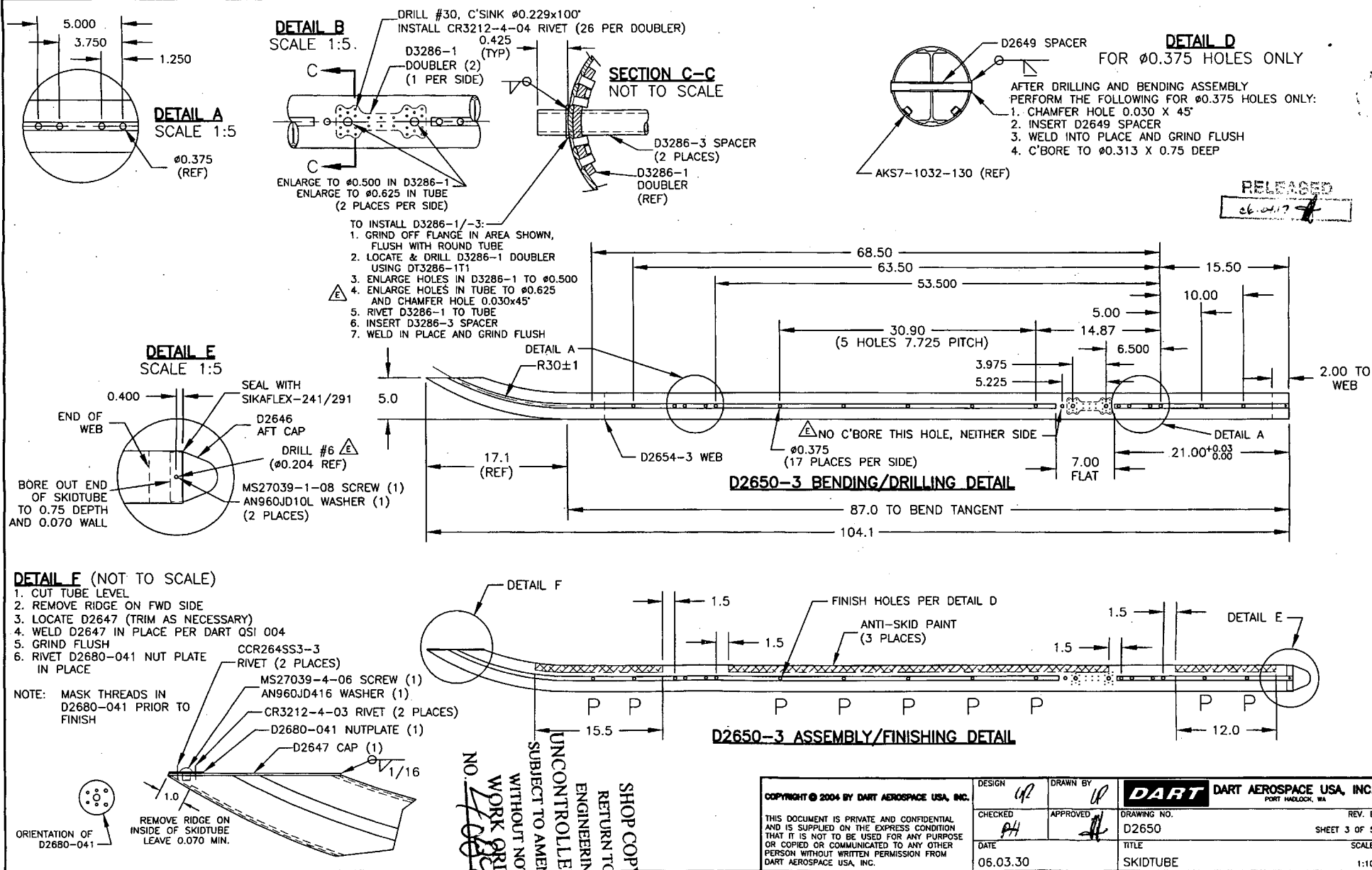
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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NO. 4000117

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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		DATE 06.03.30	TITLE SKIDTUBE	REV. E SHEET 4 OF 5 SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

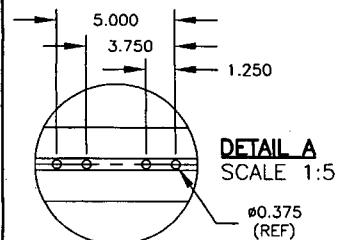
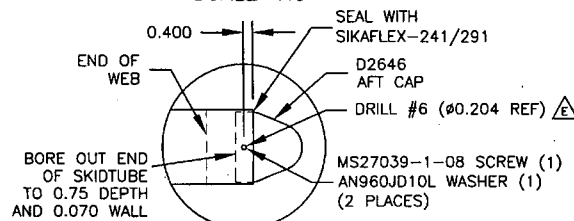
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

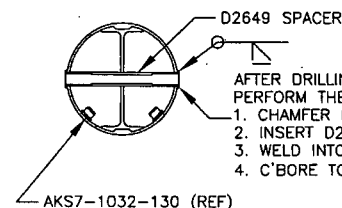
NOTE: Date & initial all entries

DETAIL E SCALE 1:5

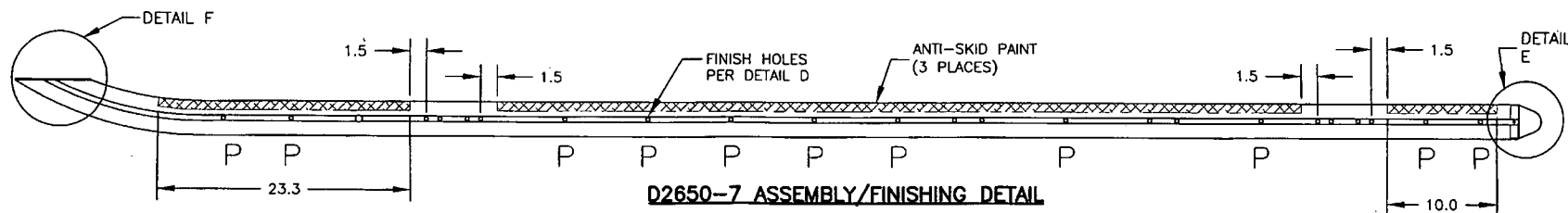
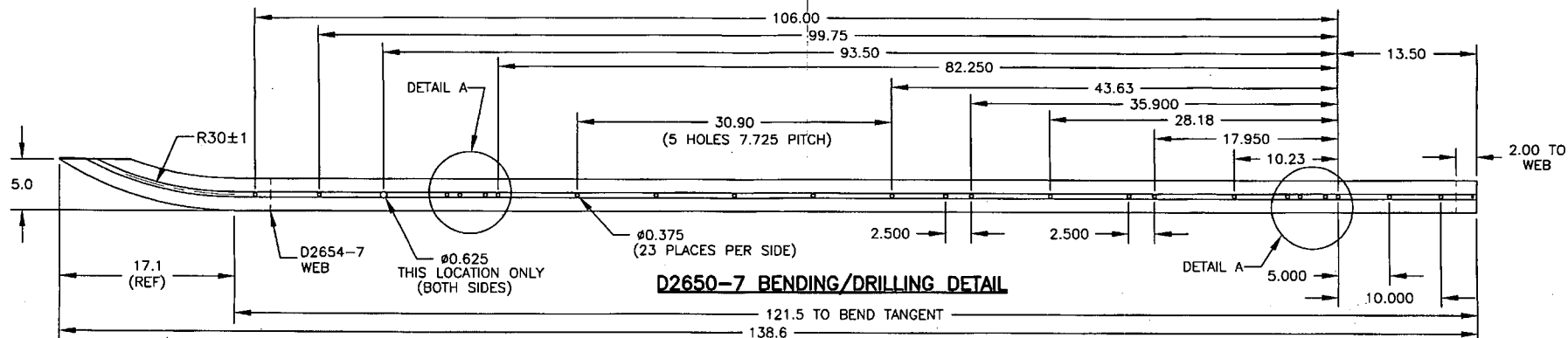


DETAIL D

FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313 X 0.75 DEEP

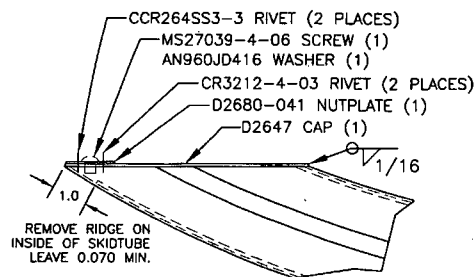


DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: FASTENERS IN D2680-041 PRIOR TO THIS DATE ARE NOT TO BE USED.

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ORIENTATION OF D2680-041

RELEASED

06.03.30

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DESIGN	UP	DRAWN BY	UP	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. E
CHECKED	PH	APPROVED	PH	DRAWING NO. D2650	SHEET 5 OF 5
DATE	06.03.30	TITLE	SKIDTUBE	SCALE	1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 1167

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 40241A
Part number: 1200 642 241
Description: 200 skid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Aluminium
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[☐]
pass[☒] fail[☐]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[☐]
pass[☒] fail[☐]
pass[☒] fail[☐]
pass[☒] fail[☐]
pass[☒] fail[☐]
pass[☒] fail[☐]

Qualifier P. D. L. Date of Test Coupon 08-08-12
Welder Barclay Elliot Date of Test Coupon 08-08-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld